

Work Order ID 148835

1488.35

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Monday, July 11, 2016 10:44:55 AM

Item ID: D2423

Revision ID:

Item Name: Lug Extrusion

Start Date: 7/11/2016 Start Qty: 288.00

Required Date: 8/8/2016 Req'd Qty: 288.00

Reference:

DAS

13

Approvals: Process Plan:

9-89

Date: JUL 11 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Accept

DAS

13

9-89

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2423	Rev B1

100 0.00

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 32973

Manufacture as per Dwg

Possible Supplier: SIGNATURE ALUMINUM

Material release note is required

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

110 0.00

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.96

3/2 JUL 11 2016

DAS

13

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352

AUG 19 2016

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Item ID: D2423 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lug Extrusion
Start Date: 7/11/2016 Start Qty: 288.00 ***288*** Cust Item ID:
Required Date: 8/8/2016 Req'd Qty: 288.00 ***288*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>meter</u>	0.00							
130									
Packaging	Memo	0.48							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	4.80							
Quality Control									

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9-89
AUG 2 3 2016

Picklist Print

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Work Order ID: 148835

148835

Parent Item: D2423

D2423

Parent Item Name: Lug Extrusion

Start Date: 7/11/2016

Required Date: 8/8/2016

Start Qty: 288.00

Required Qty: 288.00

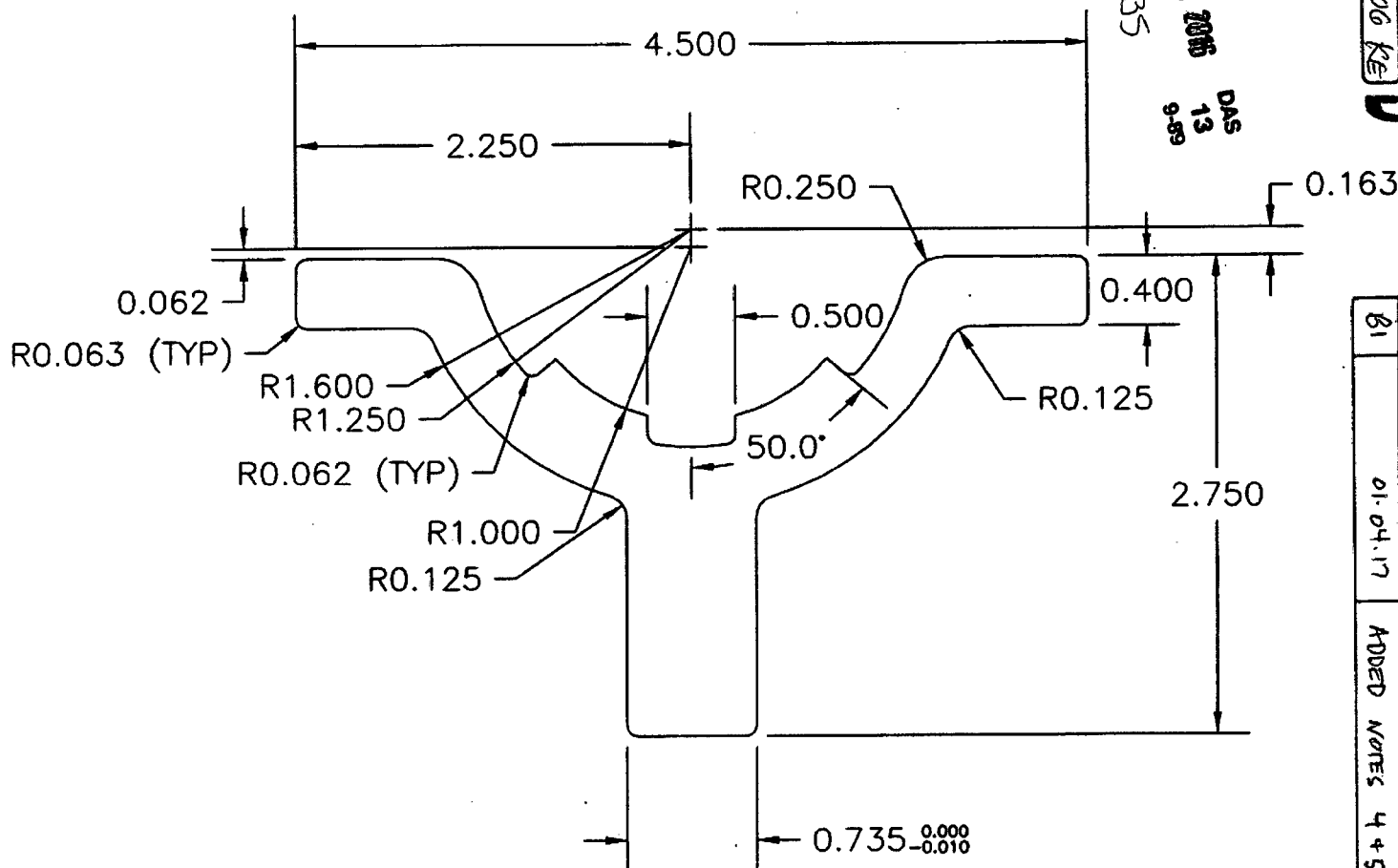
Comments: IPP G04.09.02Part Number D2423-108 changed to D2423KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423P		Purchased	No			100	f	0.0000	1	288			
D2423P									**	32		AUG 19 2016	
Lug Extrusion													

DAS
6
9-89

DART**RELEASED**
98/08/06 KEJUL 11 2006
DAS
13
9-89

010:14 8835



DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2423
DATE	TITLE	REV. B
98.08.04	LUG EXTRUSION	SHEET 1 OF 1
A	95.05.09	NEW ISSUE
B	98.08.04	6061-T6 WAS 6005A.T5
81	01.04.17	ADDED NOTES 4+5

1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARADON INDALEX DIE # MS-18866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)

DAS
13
9-89



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32973

Purchase Order Date 7/11/2016 10:55:32 AM

PO Print Date 7/11/2016

Page Number 1 of 2

Order From :

VC-BON001

SIGNATURE ALUMINUM CANADA INC.
C/O/ T10322C
P.O. BOX 4488, STN A
TORONTO, ON M5W 4H1
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED \$

Contact Name

Vendor Phone 905-427-6550

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments			Promise Date				
Delivery Comments							

1	D2423P	Lug Extrusion	8/18/2016		312.00	\$8.17	\$2,547.85
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NOTE: MATERIAL MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

AS PER DWG D2423 REV. B (EXTRUSION CUT AT 8 FT LONG)
BI48835

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE OUTSIDE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS

Line Total: \$2,547.85

2	71401-45	PROCUREMENT QUALITY CLAUSES	8/18/2016		1.00	\$0.00	\$0.00
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Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

Note:

7/11/2016

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
08/10/2016	5395132	124342	1
Guest PO	B/L No.	Lot	Date
PO32973	027683	868781	08/18/16

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No.	Part No.	Item Description	Cust Part
001	DAA-5-2	8 MILL 6061 T6	D2423P
Gross Weight	1,384 LBS		
Net Qty.	44 PCS		2 PKGS
Specification:	AMS QQA 200/8 + ASTM B221		
	Die Desc		

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
307.6 / 44.6	285.6 / 41.4	16.1	N/A	93

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.66	0.23	0.23	0.06	0.88	0.06	0.06	0.01	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com



1850 Clements Road, Pickering Ontario, Canada L1W 3R8 INVOICING AND COMPANY LOCATION

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealuminum.com

PACKING LIST

ACCT# 46024

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST DATE / DATE DU
08-18-16

PACKING LIST NUMBER / N° DE
027683

SALES ORDER NUMBER / N° DE COM
124342

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT
PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

CUSTOMER ID / ID DU CLIENT 46024	ORDER DATE / DE LA COM 07/11/16	CUSTOMER PO NUMBER / CLIENT PO Nombre PO32973	BILL OF LADING NUMBER / NO. DE CONNAISSANCEMENT 027683		LOCATION PIC	TRAILER NUMBER / REMORQUE Nombre PICKUP	SALESMAN / VENDEUR 042	CREDIT REP / REP DU CRÉDIT R. BLAIS	SALES REP / REP. DES VENTES R. BLAIS		
ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO DAA-5-2 D2423P	ALLOY & TEMPER / ALLIAGE & TEMPER 6061 T6	FINISH DESCRIPTION / DESCRIPTION DE FINITION 6061 T6	NBR OF PKGS / NBR DE PKGS 2	GROSS LBS / LIVRES BRUT 1,334	NET QUANTITY / QUANTITÉ NETTE 1,307	UNIT / UNITÉ LB	QUANTITY DUE / Quantité en raison 1,307
001	1,233	LB									
	559	KG									
	40	PC									
					Cut(+): 0.1180	Cut(-): 0.0000	Min: -10 %	Max: 10 %			
					868781 / 325762	1	487	474	16	PC	
					868781 / 325763	1	847	833	28	PC	

352 feet
P/8/16
SV

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2	1,334	1,307	LB
	605	593	KG
		44	PC
TOTALS			

DATE OF DELIVERY

DRIVER

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards set of 1930 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION